

Work Order ID 114039

March-03-14 12:40:39 PM

Split
114039

Page 1

Item ID: D3649-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Tunnel Bottom Panel Assy

5

Start Date: 3/03/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/17/14 Req'd Qty: 1.00

1

Customer:

References:

Approvals: Process Plan: M-3

Date: 14-03-03 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
----------	--------------	--	--	--	--	--	--	--	--

D3649	Rev B								
-------	-------	--	--	--	--	--	--	--	--

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100	FLOW WATER JET								
--------------	----------------	--	--	--	--	--	--	--	--

Waterjet	Memo	0.00							
----------	------	------	--	--	--	--	--	--	--

FLOW CNC Waterjet	1-Cut as per Dwg D3649 Dwg Rev: B Prog Rev: B 2-								
-------------------	--	--	--	--	--	--	--	--	--

	Deburr if necessary								
--	---------------------	--	--	--	--	--	--	--	--

6 A 14-3-10

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
-----	---	------	--	--	--	--	--	--	--

110	Memo	0.00							
--------------	------	------	--	--	--	--	--	--	--

QC									
----	--	--	--	--	--	--	--	--	--

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

6 A 14-3-10.

120	QC8- Inspect parts - second check	0.00							
-----	-----------------------------------	------	--	--	--	--	--	--	--

120	Memo	0.00							
--------------	------	------	--	--	--	--	--	--	--

QC									
----	--	--	--	--	--	--	--	--	--

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

DAS
27
9:49
14/3/11

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong								
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge								
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									

Work Order ID 114039

March-03-14 12:40:39 PM

114039

Page 2

Item ID: D3649-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Tunnel Bottom Panel Assy

Stop

NS2

Start Date: 3/03/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/17/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID
130

130

Brake NC

Brake NC

Operation
Description

Set Up/
Run Hours
0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

DAS
30
9-89

6

14/07/16

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

DAS
27
9-89
14/7/16

6

150

150

Small Fab

Small Fab

Small Fab

0.00

0.00

1- Form dimple for MS20427M3 rivet per dwg D3649*****ensure
dimples are on the proper side*****2-Assemble nutplates as per dwg
D3649

5X

14/07/18

DAS
36
9-89

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
FAULT CATEGORY									
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General					
				<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other			
				<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain				
				<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware				
				<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified				
				<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear				
				<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center				
				<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled				
				<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread				
				<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set				
				<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration				
				<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence				

Work Order ID 114039

March-03-14 12:40:39 PM

114039

Page 3

Item ID: D3649-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Tunnel Bottom Panel Assy

Stop

NS2

Start Date: 3/03/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

160

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS

27

389

4/7/18

S

170

170

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

57371

0.00

5 14/7/18

DAS

32

8-89

180

180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MJ 14-07-21

MF 14-7-18

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>				
NCR No. _____									

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General									
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>					
	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>					
	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>					
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>					
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>					
	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>						
	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>					
	Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>							
	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>							
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>							
	Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>							

• Picklist Print

Page 1

March-03-14 12:40:43 PM

Work Order ID: 114039

Parent Item: D3649-041

Parent Item Name: Tunnel Bottom Panel Assy

114039
D3649-041

Start Date: 3/03/14

Required Date: 3/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A	New Issue	07-09-26	EC	verified by: DD
IPP Rev:B	ECN 1113P	08-01-22	DD	verified by: EC
IPP Rev:C	Ecn1162	08-04-02	DD	verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S26GA		Purchased		No		150	sf	149.0000	6.069	7		**	

M304S26GA

304/316 0.018 SHEET

Location	Loc Qty	Loc Code
MAT020	149	
122753	26	
123135	123	

MS20427M3-3

MS20427M3-3

Rivet

DAS
36
9-89

MS21060-3K

MS21060-3K

Nut Plate

DAS
36
9-89

Location	Loc Qty	Loc Code
GA	491	
121114-	491	
ST335	391	
124231-	391	

42

486

22

14/07/18

77

M128879 (50x)

Location	Loc Qty	Loc Code
ST316	77	
m126826	77	

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General							
	Bending <input type="checkbox"/>	Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>			
	Centre Not Concentric <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>			
	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>			
	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>			
	Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>			
	Crushing <input type="checkbox"/>	Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
	Heat Treat <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>			
	Inspection Strip in Tube <input type="checkbox"/>	Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>					
	Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>					
	Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>					
	Wave/Twist in Tube <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>					

Picklist Print

Page 2

March-03-14 12:40:43 PM

Work Order ID: 114039

114039
D3649-041

Parent Item: D3649-041

Parent Item Name: Tunnel Bottom Panel Assy

Start Date: 3/03/14

Required Date: 3/17/14

MS21062-3K

Purchased No

150 Each

142.0000 22 22

**

DAS
3G
9-80

MS21062-3K

Nut Plate

Location	Loc Qty	Loc Code
GA	42	
124316	42	39
ST317	100	
124329	100	93

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order Update Form									
Work Order:	DISPOSITION								
Part No.	Rework	Skid-tube	Crosstube						
NCR No.	Scrap	Machining	Water Jet						
	Use-as-is	Thermoforming	Prod. Eng. Coor.						
	Suspected Unapproved	Large Fab	Rec/Store/Packaging						
		Composite	Supplier						
			Engineering Quality Other						
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
FAULT CATEGORY									
Landing Gear			General						
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced					
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up					
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure					
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld					
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled					
Crushing	Countersink	Misaligned/off center	Positioned Wrong						
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge						
Inspection Strip in Tube	Drawing	Misread							
Marks/Chatter	Drill Holes	Off-set							
Turning Sequence	Finish	Out of Calibration							
Wave/Twist in Tube	Fit/Function	Out of Sequence							

DART AEROSPACE LTD	Work Order:	114039
Description: Tunnel Bottom Panel	Part Number:	D3649-1
Inspection Dwg: D3649 Rev: B		Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.107	✓		U - Skmos	
Ø0.196	+0.005/-0.001	0.198	✓			
Ø0.250	+0.005/-0.001	0.255	✓			
0.400	+/-0.010	0.401	✓			
0.385	+/-0.010	0.386	✓			
0.250	+/-0.010	0.251	✓			
44.57	+/-0.030	44.57	✓		T SKM07	
11.70	+/-0.030	11.7	✓		"	
3.370	+/-0.030	3.370	✓		✓	
13.76	+/-0.030	13.75	✓			
4.300	+/-0.010	4.30	✓			
10.11	+/-0.030	10.115	✓			
12.90	+/-0.030	12.918	✓			
16.61	+/-0.030	16.615	✓			
15.80	+/-0.030	15.81	✓			
3.950	+/-0.010	3.958	✓			
0.42	+/-0.030	0.426	✓			
0.41	+/-0.030	0.415	✓			
0.85	+/-0.030	0.851	✓			
19.64	+/-0.030	19.648	✓			
0.54	+/-0.030	0.546	✓			
1.400	+/-0.010	1.407	✓			
2.63	+/-0.030	2.64	✓			
2.93	+/-0.030	2.93	✓			
1.49	+/-0.030	1.49	✓			
5.98	+/-0.030	6.98	✓			
0.54	+/-0.030	0.54	✓			
2.20	+/-0.030	2.20	✓			
2.75	+/-0.030	2.75	✓			
2.48	+/-0.030	2.48	✓			

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
FAULT CATEGORY									
Landing Gear				General <input type="checkbox"/> Bending <input type="checkbox"/> Bend <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> BOM/Route <input type="checkbox"/> Cracks <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Burrs <input type="checkbox"/> Cuffs <input type="checkbox"/> Contamination <input type="checkbox"/> Crushing <input type="checkbox"/> Countersink <input type="checkbox"/> Heat Treat <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Drawing <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Drill Holes <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Finish <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/> Fit/Function					
				<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled			
<input type="checkbox"/> Other									

DART AEROSPACE LTD	Work Order:	114039
Description: Tunnel Bottom Panel	Part Number:	D3649-1
Inspection Dwg: D3649	Rev: B	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.16	+/-0.030	1.16	/			
3.38	+/-0.030	3.38	/			
2.00	+/-0.030	2.00	/			
0.90	+/-0.030	0.90	/			
16.64	+/-0.030	16.64	/			
0.48	+/-0.030	0.48	/			
13.80	+/-0.030	13.8	/			
0.46	+/-0.030	0.46	/			
11.76	+/-0.030	11.76	/			
1.23	+/-0.030	1.23	/			
0.88	+/-0.030	0.89	/			
18.46	+/-0.030	18.47	/			
5.23	+/-0.030	5.23	/			
1.932	+/-0.010	1.936	/			
1.943	+/-0.010	1.944	/			
5.02	+/-0.030	5.03	/			
1.820	+/-0.010	1.825	/			
0.70	+/-0.030	0.78	/			
2.100	+/-0.010	2.110	/			
2.33	+/-0.030	2.34	/			
0.94	+/-0.030	0.96	/			
3.30	+/-0.030	3.30	/			
1.900	+/-0.010	1.9	/			
0.61	+/-0.030	0.61	/			

Measured by:	<i>DL</i>	Audited by:	<i>DAS 27</i>	Prototype Approval:	N/A
Date:	<i>14-3-10</i>	Date:	<i>14/3/10</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	<i>DL</i>

DOA:

Date:



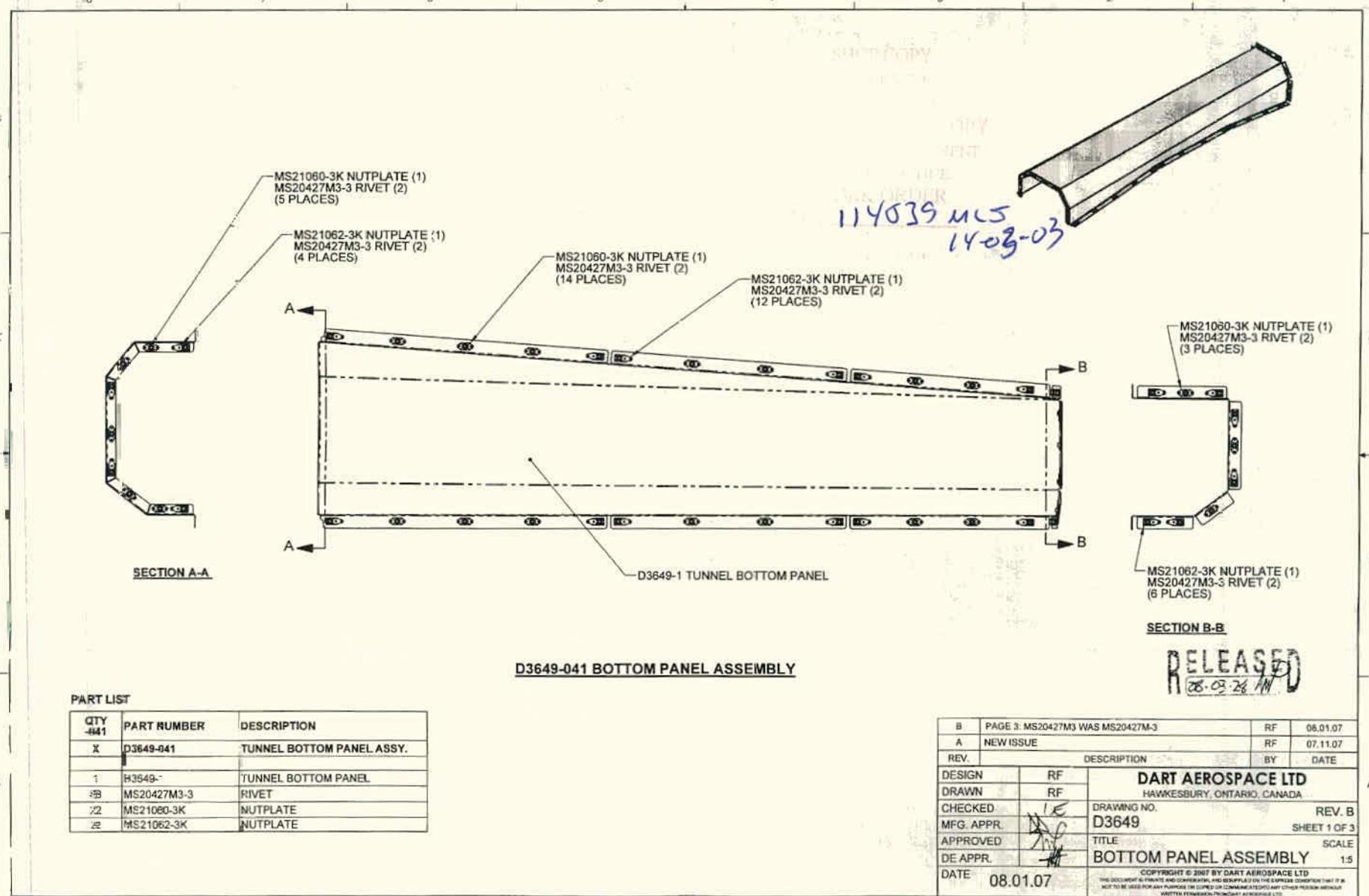
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend		Folio/Program		Outside Dimensions		Pressure/Forced				
Centre Not Concentric	BOM/Route		Grain		Over/Under tolerance		Set-up				
Cracks	Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure				
Crimp/Kink/Ripple/Wave	Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld				
Cuffs	Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled				
Crushing	Countersink		Misaligned/off center		Positioned Wrong						
Heat Treat	Cut Too Short		Mislabeled		Power Loss/Surge						
Inspection Strip in Tube	Drawing		Misread								
Marks/Chatter	Drill Holes		Off-set								
Turning Sequence	Finish		Out of Calibration								
Wave/Twist in Tube	Fit/Function		Out of Sequence								



DQA: _____ Date: _____

Date:

WORK ORDER NON-CONFORMANCE / UPDATE

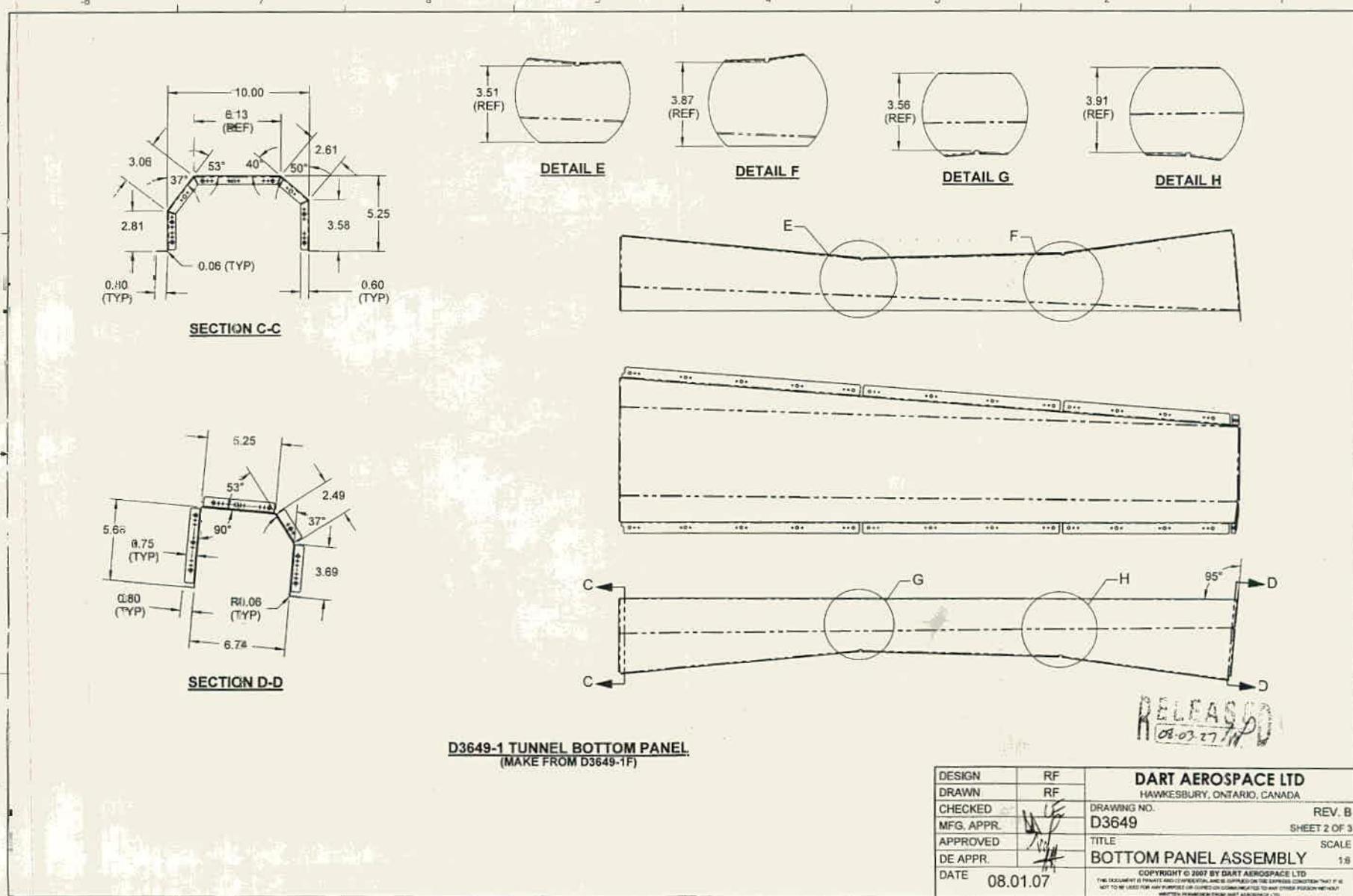
QA Closed: _____ Date: _____

Date:

Work Order update only



Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS																																							
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>																																					
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																																			
Design <input type="checkbox"/>	Doc/Data <input type="checkbox"/>	Equip/Tooling <input type="checkbox"/>	Handling/Pre <input type="checkbox"/>	Material <input type="checkbox"/>	Operator <input type="checkbox"/>	Offset/Setup <input type="checkbox"/>	Process <input type="checkbox"/>	Supplier <input type="checkbox"/>	Training <input type="checkbox"/>	Transport <input type="checkbox"/>	Unapproved <input type="checkbox"/>																																		
FAULT CATEGORY																																													
Landing Gear				General																																									
Bending <input type="checkbox"/>	Centre Not Concentric <input type="checkbox"/>	Cracks <input type="checkbox"/>	Crimp/Kink/Ripple/Wave <input type="checkbox"/>	Cuffs <input type="checkbox"/>	Crushing <input type="checkbox"/>	Heat Treat <input type="checkbox"/>	Inspection Strip in Tube <input type="checkbox"/>	Marks/Chatter <input type="checkbox"/>	Turning Sequence <input type="checkbox"/>	Wave/Twist in Tube <input type="checkbox"/>	Bend <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Burrs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Countersink <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Drawing <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Finish <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Grain <input type="checkbox"/>	Hardware <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Misread <input type="checkbox"/>	Off-set <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>	Set-up <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>	Weld <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	Other <input type="checkbox"/>



DQA:

Date: _____



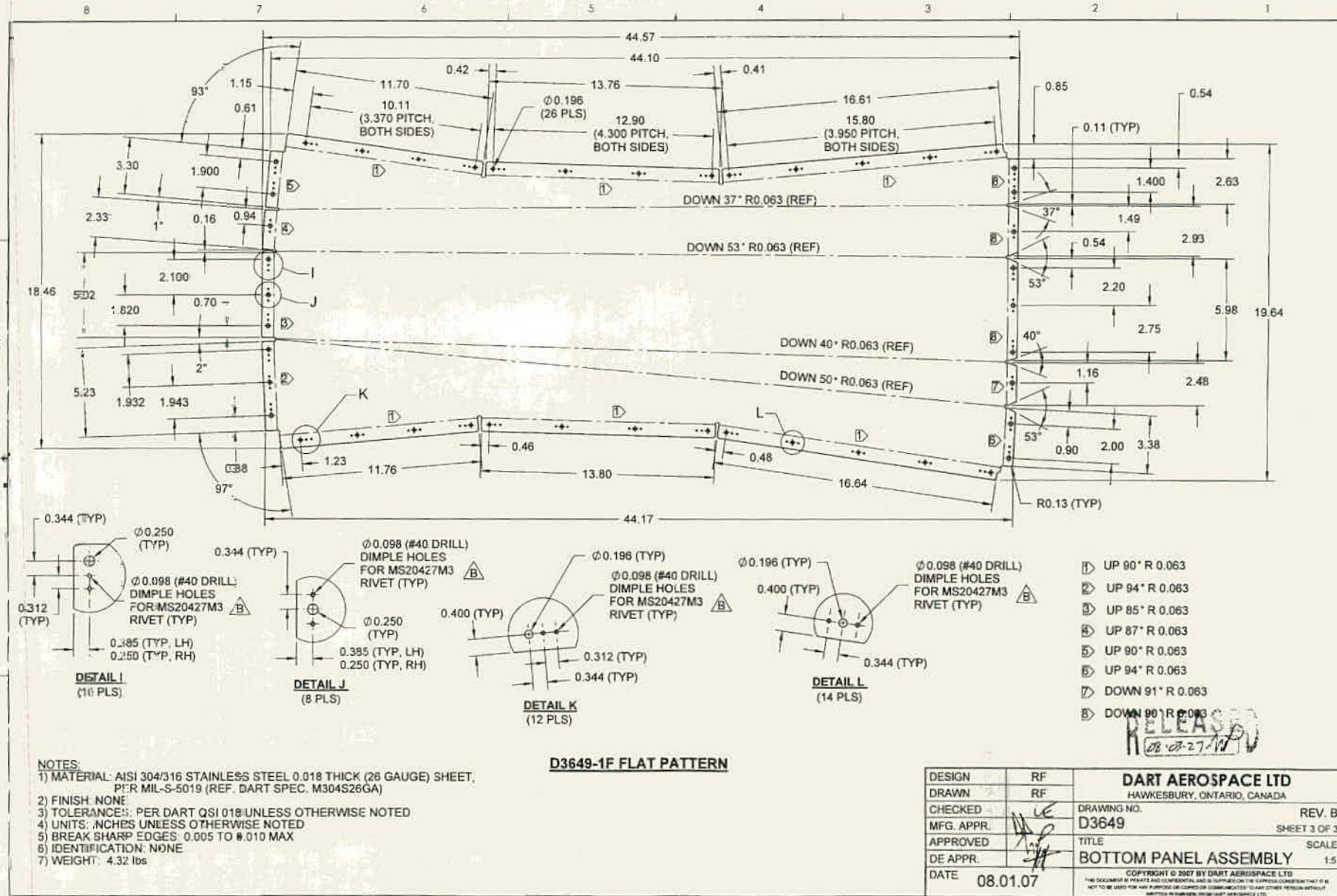
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>		Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>		
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>		Prod. Eng. Coor. <input type="checkbox"/>		Quality <input type="checkbox"/>		
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>		Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>		
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced							
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up							
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure							
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld							
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled							
Crushing	Countersink	Misaligned/off center	Positioned Wrong	Other							
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge								
Inspection Strip in Tube	Drawing	Misread									
Marks/Chatter	Drill Holes	Off-set									
Turning Sequence	Finish	Out of Calibration									
Wave/Twist in Tube	Fit/Function	Out of Sequence									



DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only